Date: Friday, 2/23/2007 8:31:40 AM
User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: WEB
Job Number	: 30884		
Estimate Number	: 10498		
P.O. Number	: N/A	Part Number	: D2739
This Issue	: 2/23/2007 S.O. No. : N/A	Drawing Number	: D2739 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: N/A Type : LANDING GEAR	Drawing Revision	: C
Previous Run	: 30649	Material	: N/A
Written By	:	Due Date	: 3/10/2007 Qty: 4 Um: Each
Checked & Approved By	: 9/02.02.23		
Comment	: Est Rev: C 02.11.28 Reformat KJ		
	Est Rev: D 06-03-21 As Per Rev C JLM		

Additional Product

Job Number:

Seq. #:	Machine Or Operation:	Description :
1.0	D26005108	Extrusion 'I Beam' thin

Comment: Qty.: 1.0000 Each(s)/Unit   Total : 4.0000 Each(s)
Extrusion 'I Beam' thin
Pick:
Qty Part Number Description Batch
1   D2600-5   Web   B34410

Pmc/ JD 7-2-26

Seq. #:	Machine Or Operation:	Description :
2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1

Comment: LANDING GEAR RESOURCE 1
1-Cut D2600-5 to length as per Dwg D2739. *Pmc/ JD*

2-Drill pilot holes in web using drilling Jig DT8162 as per Dwg D2739 *Pmc/ JD*

3-Use uni-bit to open holes to finish size as per Dwg D2739. *Pmc/ JD*   *7-2-27 (4)*

4-Bevel Fwd ends (1" max) of extrusion and Deburr holes and ends. *Pmc/ JD*

5-Dburr *Pmc/ JD*

Seq. #:	Machine Or Operation:	Description :
3.0	QC5	INSPECT WORK TO CURRENT STEP

Comment: INSPECT WORK TO CURRENT STEP *BE 07-02-27*

Seq. #:	Machine Or Operation:	Description :
4.0	HAND FINISHING1	HAND FINISHING RESOURCE #1

Comment: HAND FINISHING RESOURCE #1
Acid etch and Alodine as per QSI 005 4.1   *JD 7-3-27*

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WORK ORDER CHANGES

W/O:								
DATE	STEP	PROCEDURE CHANGE		By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes (No) DQA: _____ Date: 07/03/08

QA: N/C Closed: _____ Date: _____

WORK ORDER NON-CONFORMANCE (NCR)

NCR:								
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: WEB

Job Number: 30884

Part Number: D2739

Job Number:

Seq. #:	Machine Or Operation:	Description :

5.0   QC3   INSPECT POWDER COAT/CHEMICAL CONVERSION

Pm '07-03-08 ④

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

6.0   PACKAGING 1   PACKAGING RESOURCE #1

Comment: PACKAGING RESOURCE #1

Use a red or black lead-free paint pen to write the part number and batch number in the middle of each web.

Identify and Stock
Location: LG   JD   7-2-27

7.0   QC21   FINAL INSPECTION/W/O RELEASE

④

Comment: FINAL INSPECTION/W/O RELEASE   07/03/08

Job Completion   U 07-03-08

Form: rprocess

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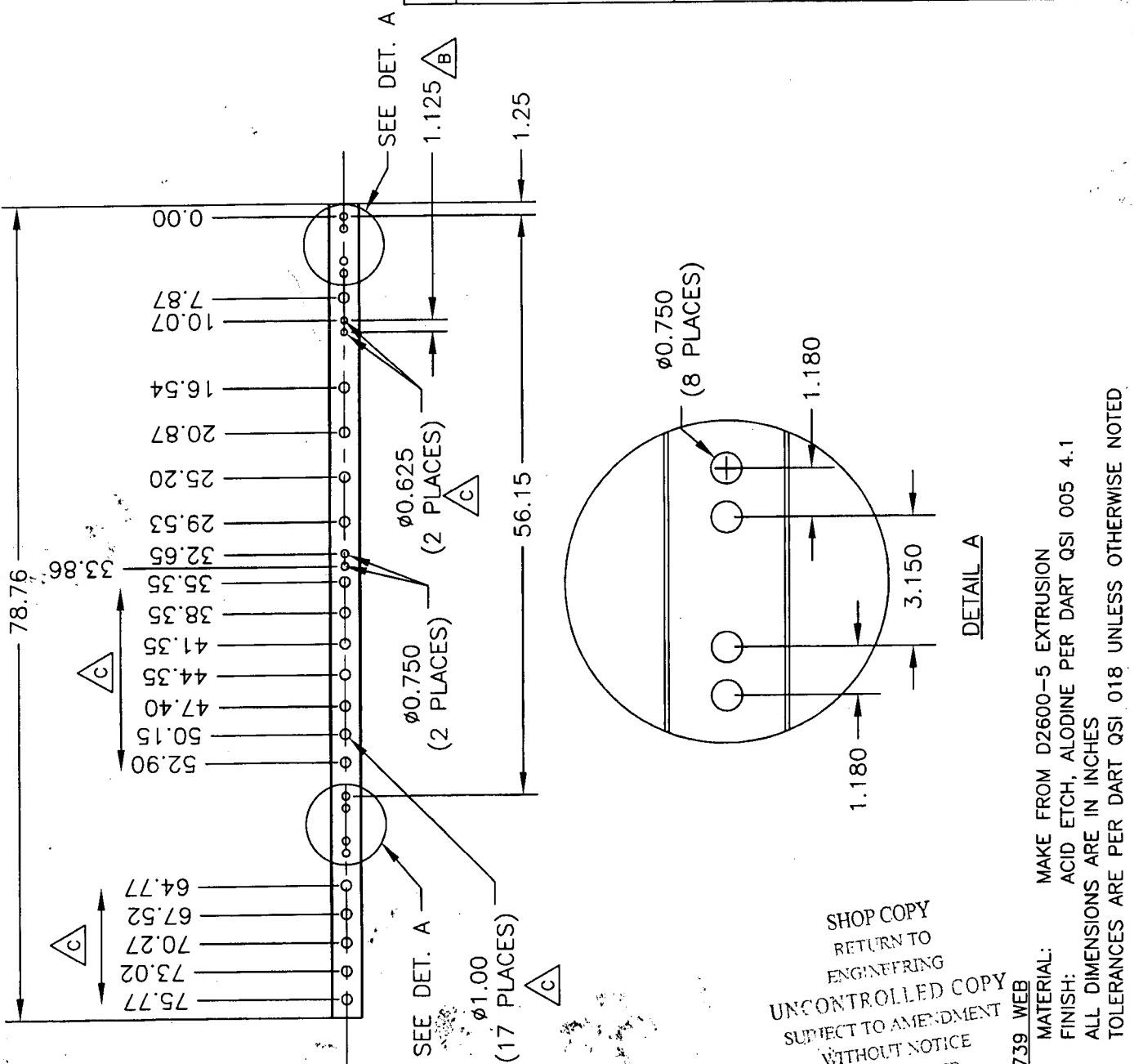| W/O:		WORK ORDER CHANGES						
DATE	**STEP**	**PROCEDURE CHANGE**	**By**	**Date**	**Qty**	**Approval** Chief Eng / Prod Mgr	**Approval** QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B			**Verification** Section C	**Approval** Chief Eng	**Approval** QC Inspector
DATE	**STEP**	**Description of NC** Section A	**Initial** Chief Eng	**Action Description** Chief Eng	**Sign & Date**			

NOTE: Date & initial all entries

DART

RELEASED

SEE DET. A

1.125 B

1.25

0.00
7.87
10.07
16.54
20.87
25.20
29.53
32.65
33.86
35.35
38.35
41.35
44.35
47.40
50.15
52.90
64.77
67.52
70.27
73.02
75.77

78.76

56.15

Ø0.625 (2 PLACES) C

Ø0.750 (2 PLACES)

SEE DET. A

Ø1.00 (17 PLACES) C

C

Ø0.750 (8 PLACES)

1.180

3.150

1.180

DETAIL A

MAKE FROM D2600-5 EXTRUSION
ACID ETCH, ALODINE PER DART QSI 005 4.1

D2739 WEB
1) MATERIAL:
2) FINISH:
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 39884